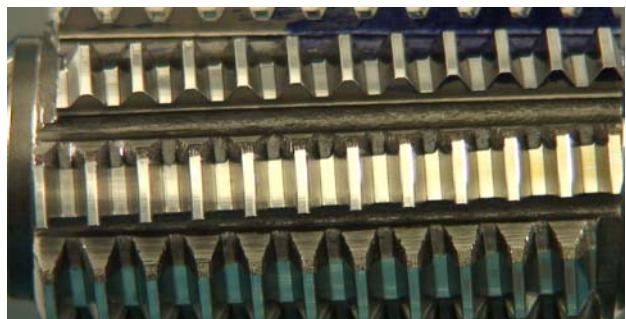


Gear Hob Ø100 L100mm

A12-030

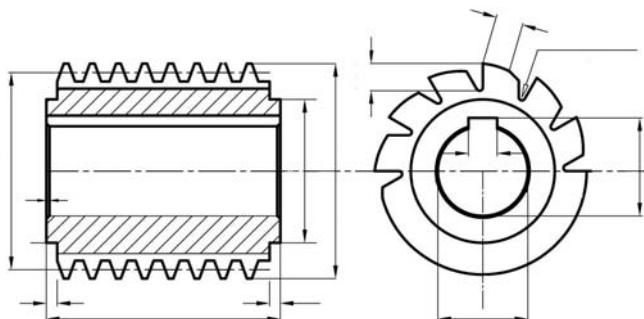
The preturned gear hob is usually profiled with a conventional wheel, which is formdressed on the integrated CNC dressing unit. With the highly dynamic linear axis of the machine, the profile execution is done at high frequency. The cycle time includes a dressing starting from a cylindrical wheel. In case the wheel is already formed the cycle time reduces drastically.



1. Cycletime for Production

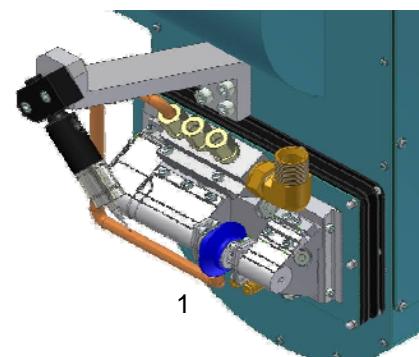
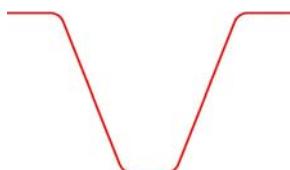
Tool specifications			
Diameter 100 mm, Length 100mm, Material HSS, 12 Gashes, 68 Teeth			
Operations	Probe	Dress	Grind
Feed [mm/Min]	2000	150	3500
Power [kW]		1	1
Cutting feed [m/s]		32	24
Used wheels	full		1
Grinding time [s]	20	1800	1740
Total cycle time	59 Min 20		

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

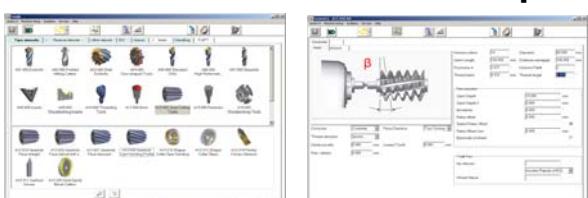


2. Used Grinding Wheels

1 Ø40 DXF Conventional



3. Machine and Software Requirements



Machines: 5 axes CNC grinders : **GEMINI hhp**
 Control: Fanuc 310iA5
 Coolant: Synthetic Oil, pressure 6 - 7 bar
 Software: Quinto5, GearHobs
 Engineer: DI, 04.05.2009